



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D205-596-101
Job Sheet 161362



Part No: D205-596-101

Job Qty: 1 ea

Part Name: Fwd Crosstube - Extended Height 39"



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 11/15/17

Created By: Mario Poulin

Type: Stock

Description:

Customer: Kestrel Aviation Pty Ltd (CKEST03)

325 Aerodrome Road Mangalore, Victoria, 3663 Australia

Note: DWG REV B(DEO) U/R IPP Rev G Removed Bending 05-10-25 JLM IPP Rev:H ECN 1075 08-01-10 DD IPP Rev I 08.04.28 Added bending & mat'l EC verified by: DD IPP Rev:J 08-08-19 remove QC4 DD verified by:EC IPP REV:K 13.11.29 as per dwg DEO B-2 DD VERF:JLM

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial
D205-596-101 Fwd Crosstube - Extended Height 39"	DWG REV B(DEO) U/R IPP Rev G Removed Bending 05-10-25 JLM IPP Rev:H ECN 1075 08-01-10 DD IPP Rev I 08.04.28 Added bending & mat'l EC verified by: DD IPP Rev:J 08-08-19 remove QC4 DD verified by:EC IPP REV:K 13.11.29 as per dwg DEO B-2 DD VERF:JLM	
D2893-1 Support	DWG REV C IPP: C 02.11.26 Reformat; Added P/O KJ IPP D 06.04.19 removed alodine EC IPP Rev:E Added priming as per Rev B 07-04-30 JLM IPP F 08.03.19 Re-format EC verified by: DD IPP Rev:G 08-05-15 add QC14 DD verified by:EC IPP Rev:H 11.08.04 as per dwg rev.C DD verf:EC	
D3595-063-450 Rubber Cushion 0.63" Wide X 4.50" Long	DWG REV A IPP Rev:A New Issue 07-08-07 JLM Verified By:	
D6005-180 Crosstube Material	DWG REV B	
MS21920-25 Clamp		

Status: Stock

Part: **D205-596-101 B161362**
Created: 9/30/17 11:27 AM DART.MICHAUD.
FEBRILLE VICTORIA



Serial No: **S000054**
Printed By: Goldston, Justin 10/2/17 10:44 AM

Job Routing

Op No	Operation	Qty	Due Date	Standard Setup hrs	Run Hrs	Workcenter / Supplier	Le
90	Start up Operation	1 Ea	11/14/17	0.00	0.00	Start up container	3m
100	DC	1 pcs	11/14/17	0.00	0.00	DC	A7
105	HandFXtube	1 pcs	11/14/17	0.00	0.00	HandFinish5	
107	QC	1 pcs	11/14/17	0.00	0.00	QC7	
110	CNC Bend Crosstubes	1 pcs	11/15/17	1.84	0.00	CNC Bend Crosstube	
130	QC	1 pcs	11/15/17	0.00	0.00	QC15	
140	Crosstubes	1 pcs	11/15/17	0.00	0.00	Crosstube	
150	HandFXtube	1 pcs	11/15/17	0.00	0.00	Crosstube	
160	QC	1 pcs	11/15/17	0.00	0.00	QC7	
170	QC	1 pcs	11/15/17	0.00	0.00	QC5	
180	SprayPaint	1 pcs	11/15/17	0.00	0.00	Spray Paint	
190	QC	1 pcs	11/15/17	0.00	0.00	QC14	
200	Crosstubes	1 pcs	11/15/17	0.00	0.00	Crosstube	
210	QC	1 pcs	11/15/17	0.00	0.00	QC5	
220	Packaging	1 pcs	11/15/17	0.00	0.00	Packaging3	Smb

Plex 10/1/17 2:17 PM Dart.

f2080

1270 ABERDEEN ST HAWKESBURY ON CANADA K6A 1K7 TEL: 1 613 632-5200 www.dartaero.com	
CHG003	CHG
SH03-6	STC
SR01742NY	STC
STC	STC
DART aerospace	
N/A	D205-596-101
P/N	Crosstube Fwd Extended
ESC	B152054
LOT	Rev: 26/4/20/5/210/212/214/412/411-1
ODEL	

DART
AEROSPACE
S031215

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Fwd Crosstube – Extended Height 39"

PART NO: D205 – 596 – 101

Revision:

Operation: Start up Operation

Change No: CHG003

Mfg Date: 01/11/18

Job No: 161362

230	QC21-FG	1 Ea	11/15/17	0.00	0.00	QC21
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Part Op 105 - INSIDE AND OUT

Descriptions: **110** - Bend as per Dwg D2889 using CNC bender program
130 - Mark 38.3" for cutting from tangential line in the straight section from D2889 as per Dwg wall template. ***Identify off-cuts with batch number & part number and bring them to cnc lathe***
140 - 1-Cut as per Dwg D205-596-101 2-Debur & Inspect for surface damage. Polish cut surface. Scribe part # and Batch # on one end of tube.
150 - ***IMMEDIATELY AFTER GRINDING***
180 - 1-Prime inside and outside per QSI 005 4.2 PRIMER BATCH: _____ 2- Paint outside as per dwg QSI 005 4.2 PAINT BATCH: _____
200 - 1- Lightly scuff the bonded area using a 180 grit sand paper and clean the area with 41058 wash 'n' wipe 2- Apply Proseal as per dwg D205-596-101 (DEO). A/R Proseal 890 B-2 Batch: _____ EXP: _____ 3- Torque clamps 80 to 100 in-lb as per dwg and Note 11 (DEO B-2)
210 - ***PRIOR TO PACKAGING RECHECK TORQUE ON CLAMPS AFTER PROSEAL HAS CURED 72HOURS.***
220 - Identify and pack for shipping as per PPP D205-596-101

Job BOM

Part / Item	Component Name	Quantity	Operation	Special Comments
D6005-180	Crosstube Material	1 Ea (1 ea)	90-Start up Operation	
D2893-1	Support	2 Ea (2 ea)	200-Crosstubes	
D3595-063-450	Rubber Cushion 0.63" Wide X 4.50" Long	4 Ea (4 ea)	200-Crosstubes	
MS21920-25	Clamp	4 Ea (4 ea)	200-Crosstubes	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6005-180	1	0	0	0
200-Crosstubes	D2893-1	2	0	0	0
	D3595-063-450	4	0	0	0
	MS21920-25	4	0	0	0

Part Specifications

Specifications could not be found.

Plex 10/1/17 2:17 PM Dart.Baker.Diane

Work Order ID 161362

161362

Page 1

Friday, June 09, 2017 2:24:13 PM

Item ID:	D205-596-101	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:	URF 14-644				Stop	*NS2*
Item Name:	Fwd Crosstube - Extended Height 39"					
Start Date:	6/9/2017	Start Qty:	1.00	*1*	Cust Item ID:	
Required Date:	6/9/2017	Req'd Qty:	1.00	*1*	Customer:	
Reference:	RA112515					
Approvals:	Process Plan:	Date:	JUN 09 2017	Tooling:	Date:	
	QC:	Date:		SPC (Y/N):	Date:	
					Run	Start
						NR1
					Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D205-596-101	Rev B(DEO) U/R								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy D205-594 bluefile & type labels per PPP D205-596-101 CHG003								
106		0.00							
106									
QC	Memo	0.00							
Quality Control	INPSECT RA112515 CUSTOMER ORDERED D205-596-105 B153346 BUT RECEIVED D205-596-101 B152054								

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
☐ OTHER : _____					

Friday, June 09, 2017 2:24:13 PM

Item ID: D205-596-101

Accept

N900040100

Setup Start *NS1*

Revision ID: URF 14-644

Item Name: Fwd Crosstube - Extended Height 39"

Stop *NS2*

Start Date: 6/9/2017 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 6/9/2017 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference: RA112515

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NB2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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220

0.00

220

Packaging

0.00

Packaging

Packaging

Memo-

REPACKAGE USING NEW B/N

Identify and pack for shipping as per PPP D205-596-101
Location: _____

230

QC21- Final Inspection - Work Order Release

0.00

230

QC

Memo

0.10

Quality Control

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
		OTHER : ☐				

Friday, June 09, 2017 2:24:18 PM

Parent Item: D205-596-101

Parent Item Name: Fwd Crosstube - Extended Height 39"

Required Date: 6/9/2017

Required Qty: 1.00

IPP Rev G Removed Bending 05-10-25 JLM
IPP Rev:H ECN 1075 08-01-10 DD
IPP Rev I 08.04.28 Added bending & mat'l EC verified by: DD
IPP Rev:J 08-08-19 remove QC4 DD verified by:EC IPP REV:K
13.11.29 as per dwg DEO B-2 DD VRF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D205-596-101		Manufactured	No				Each	1.0000		1		JUN 09 2017	
D205-596-101									**	(Signature)			
Fwd Crosstube - Extended Height 39"													
				<u>Location</u>				<u>Loc Qty</u>					
				bsk005				1					
					152063			1					

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Inspection Sheet Complete **RA112515**

Customer QA Ref #									0
Part Number	Batch / Serial #	Quantity	Part Complete	Rev/CHG Current	New Paperwork	New Labels	Disposition	Work order #	Work order Instructions
D205-596-101	B152054	1	☒ Yes	☒ Yes	☒ Yes	☒ Yes	STOCK	161362	Kit complete. Repackage as per PPP. Stock with new batch number at CHG 003. Add new labels and paper work.
0		0	☐ Yes	☐ Yes	☐ Yes	☐ Yes			
0		0	☐ Yes	☐ Yes	☐ Yes	☐ Yes			
0		0	☐ Yes	☐ Yes	☐ Yes	☐ Yes			
0		0	☐ Yes	☐ Yes	☐ Yes	☐ Yes			
0		0	☐ Yes	☐ Yes	☐ Yes	☐ Yes			

QC Approval: P.D. _____

Date: 12-May-17 _____

Location/Lot Activity

Wednesday, June 28, 2017 8:54:45 AM

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Criteria : All Items All Locations Lot: 152054 All Transaction Types All Dates Report on Locations & Lots

Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Account Value Change	D205-596-101 / Fwd Crosstube - Extended Height 39"	Main Warehouse		Laje01		1.0000		1.0000		
		bsk005			2/24/2017	-1.0000	152054	-1.0000		(\$2,159.60)
		Main Warehouse		Laje01		1.0000		1.0000		
		bsk005			2/24/2017	1.0000	152054	1.0000		\$2,159.60
								0.0000		\$0.00
Rework	D205-596-101 / Fwd Crosstube - Extended Height 39"	Main Warehouse	161362	LACE01		2.0000		1.0000		
		bsk005			6/9/2017	-1.0000	152054	-1.0000		(\$2,159.60)
								-1.0000		(\$2,159.60)
WIP Receipt	D205-596-101 / Fwd Crosstube - Extended Height 39"	Main Warehouse	152054	Laje01		0.0000		0.0000		
		bsk005			1/19/2017	1.0000	152054	1.0000		\$2,159.60
								1.0000		\$2,159.60

Change Record

PAGE 1 OF 1

Part Number: D205-596-101/-103/-105/-107

Description: CROSSTUBE ASSEMBLIES

[illegible]